

Date: Thursday, 4/12/2007 8:52:30 AM  
 User: Kim Johnston

## Process Sheet

Split SP 07/05/11

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	LH ACTUATOR ASSEBLY
Job Number	31745-2	Part Number	41232 200 001 001
Estimate Number	12761	Drawing Number	41232-200-001 REV IR
P.O. Number	N/A	Project Number	N/A
This Issue	4/12/2007	Drawing Revision	IR
Prsht Rev.	NC	Material	N/A
First Issue	N/A	Due Date	5/10/2007
Previous Run	31450	Qty:	4
Written By		Um:	Each
Checked & Approved By	JL		
Comment	Est Rev.A New Issue 07-02-28 JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	MS208224	elbow	
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) elbow Batch: M103688		SP 07/05/15 ③
2.0	124K002 4CR 0545	Hose ass'y-Step Actuator	
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) Hose ass'y-Step Actuator BATCh: _____		720f of packing kit u
3.0	AN8424D	Elbow	
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) Elbow Batch: M104156		SP 07/05/15 ③
4.0	41232 200 007 001	Brass Cylinder Assembly	
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) Brass Cylinder Assembly Batch: B30942		SP 07/05/15 ③
5.0	MS1699623	cap screw	
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) cap screw Batch: M103934		SP 07/05/15 ③

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07/05/11	14	Split w/o			SB	07/05/11	3		

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 4/12/2007 8:52:30 AM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LH ACTUATOR ASSEMBLY

Job Number: 31745

Part Number: 41232 200 001 001

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 AN3154R Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

Batch: M 17566

SB 07/05/15 ③

7.0 AN960JD416 Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Washer

Batch: M 162929

SB 07/05/15 ③

8.0 AN960JD10 Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Washer

Batch: M 100743

SB 07/05/15 ③

9.0 MS21042L3 Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

Batch: M 104215

X

10.0 AN322A Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch: M 3413

SB 07/05/15 ③

11.0 41232 200 005 003 Spacer (Step Actuator)



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Spacer (Step Actuator)

Batch: B 31022

SB 07/05/15 ③

12.0 41232 200 002 005 pivot arm



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

pivot arm

Batch: B 31021 ①

(B 31775 ②) X

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: SD Date: 07/05/17  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 4/12/2007 8:52:30 AM

User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LH ACTUATOR ASSEMBLY

Job Number: 31745

Part Number: 41232 200 001 001

Job Number:



Seq. #: Machine Or Operation:

Description :

13.0

41232 200 002 003

latch



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

latch

Batch: B 31777

14.0

41232 200 002 001

tube



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

tube

Batch: B 31019 ①

B 31776 ②

15.0

41232 200 008 001

Decal



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Decal

Batch: H 31023

SB 07/05/15 ③

16.0

SMALL FAB 1

SMALL &amp; MEDIUM FAB RESOURCE 1



Comment: SMALL &amp; MEDIUM FAB RESOURCE 1

1- Assemble as per Dwg 41232-200-001

2-Torque as per Dwg 41232-200-001

SB 07/05/15 ③

17.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

18.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

P. 110/17 (3)

19.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

D 07/05/17 (3)

Job Completion



JL J.05/17

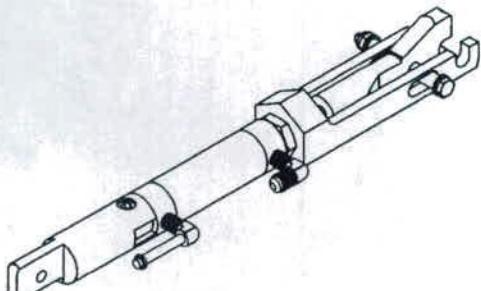
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07/05/15		Spring S1455 Batch M104079 Put on E-Rozer Batch M104251	SB	07/05/15	3	07/05/17	07/05/17

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

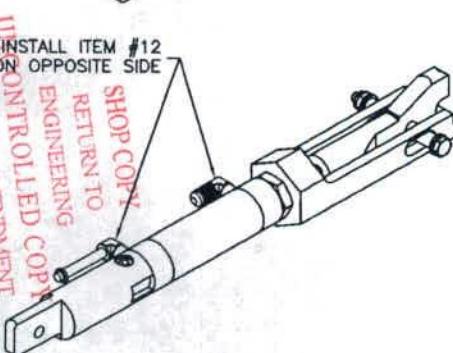
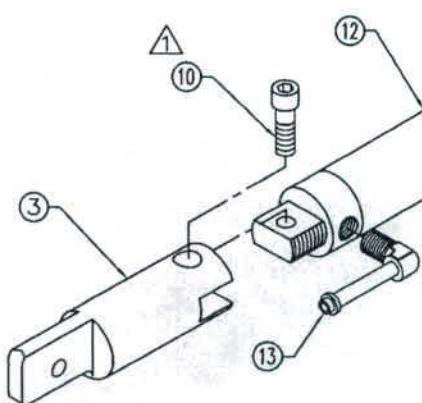
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



-001 L/H ACTUATOR ASSY

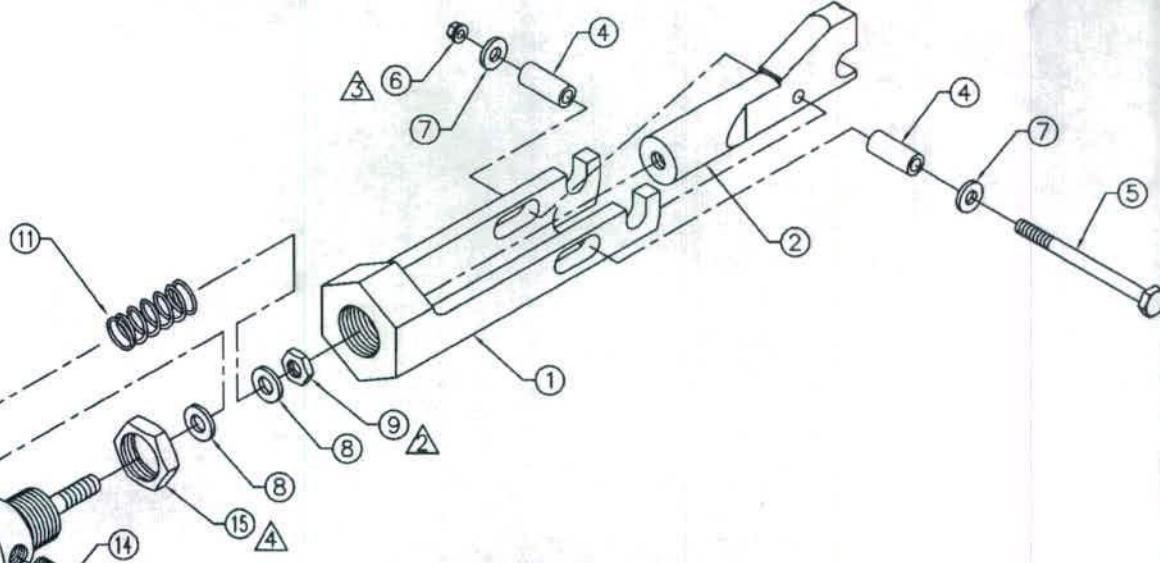


-002 R/H ACTUATOR ASSY

NO. 31745  
WORK ORDER  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
ENGINEERING  
RETURN TO  
INSTALL ITEM #12  
ON OPPOSITE SIDE  
SHOP COPY

- TORQUE 80-100 IN.-LB.
- TORQUE 20-25 IN.-LB.
- TORQUE 50-75 IN.-LB.
- TORQUE 50-75 IN.-LB.

NOTES:



1	1	15	3/4x20 BRASS	CYLINDER NUT				
1	1	14	MS20822-4	ELBOW				
1	1	13	AN842-4D	ELBOW				
1	1	12	41232-200-007-001	CYLINDER				
1	1	11	71459	SPRING				
1	1	10	MS16996-23	CAP SCREW				
1	1	9	AN315-4R	NUT				
2	2	8	AN960JD416	WASHER				
2	2	7	AN960JD10	WASHER				
1	1	6	MS21042-L3	NUT				
1	1	5	AN3-22A	BOLT				
2	2	4	41232-200-005-003	SPACER				
1	1	3	41232-200-002-005	PIVOT ARM				
1	1	2	41232-200-002-003	LATCH				
1	1	1	41232-200-002-001	TUBE				
			-002	R/H ACTUATOR ASSY				
			-001	L/H ACTUATOR ASSY				
-002	-001	REV. NO.	PART NO.	NAME	STOCK SIZE	MATERIAL	MATL.SPEC	ZONE
LIST OF MATERIAL								

PROPRIETARY RIGHTS NOTICE		UNLESS OTHERWISE SPECIFIED	DRAFTSMN D. NELSON 5/20/02	TITLE STEP ACTUATOR ASSY					
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-002	-001	1	41232-000-001	RECD. BY	DATE	PROJ. ENGR.	DRAW. SIZE C	SCALE NONE	
DRAFTS. INC.		RECD. PER ASSY	NEXT ASSEMBLY	REL.	FINISH	<i>Era Aviation, Inc.</i>			DWG. NO. 41232-200-001 REV. IR

